

# Work Order ID 50214

July 14, 2009 2:42:32 PM



Page 1

Item ID: D3531-3

Accept



Setup Start



Revision ID: A

Item Name: Bracket Front Plate

Stop



Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3531

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3531

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 9-8-4

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-8-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

z> 809/08/04

(12) /

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Page 2

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Accept



Setup Start



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Stop



Item Name: Bracket Front Plate

Start Date: 7/15/09

Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

via

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3530

0.00

0.00

88 09/08/13

12

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 88 08/08/13

42

# Work Order ID 50214

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Page 3

Item ID: D3531-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Front Plate

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9/1 09-08-14 (121)

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

G.R. 09-08-14 (12)

180

Identify as per dwg & Stock Location: 110

0.00



Packaging

Memo

0.00

Packaging

9/8/14 (12) 89

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Page 4

Item ID: D3531-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Front Plate

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/18 *HJ*

*MF 09-08-17*

# Picklist Print

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Page 1

Work Order ID: 50214

Parent Item: D3531-3RevA

Parent Item Name: Bracket Front Plate

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	158.2680	0.6911	12		



6061-T6 .040 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	158.268	
100742	3.3	
102723	7.93	
105842	12	
106747	12.5	
107461	19.42	
109396	22.28	
111224	79.338	
19380	1.5	

111224

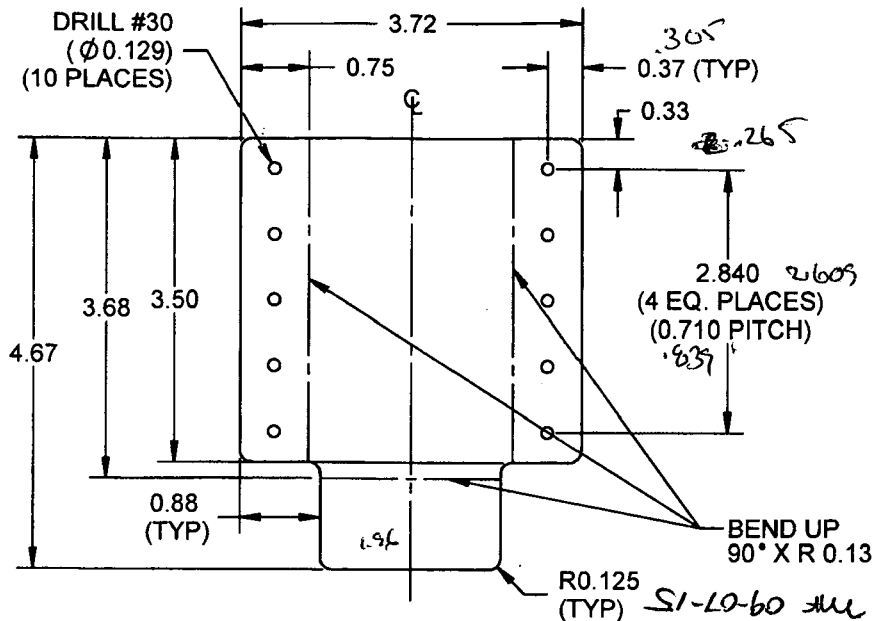
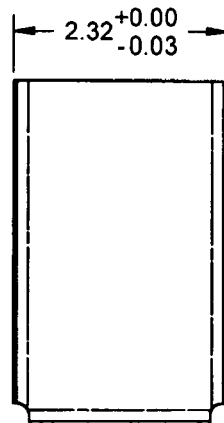
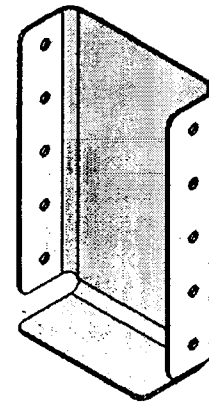
113 9-8-4

12

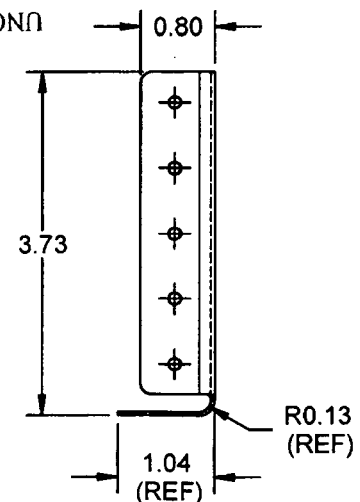


**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3531</b>	REV. A SHEET 3 OF 3
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:2

**D3531-3F FLAT PATTERN****RELEASED**  
07.08.03

NO. 52014  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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